

# Work Order ID 67818

Thursday, March 31, 2011 11:48:21 AM



Page 1

Item ID: D407-667-205TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 3/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D407-667-245	Rev F								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8531 on both ends as per Folio FA248□2-Turn first side as per Folio FA248□3- File transition lines smooth.

mm.c 11/05/11

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

cmh 11/05/20

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA248□2- File transition lines smooth.□3- Remove sand and plugs□4-Scribe part # and batch # using vibrating stylus as per Dwg D407-667-245 □Inside of Cuff(Donot engrave on outside of tube)

mm.c 11/05/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67818**

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Page 2

Item ID: D407-667-205TRN

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Revision ID:

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Start Date: 3/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

on 4/05/20

1 0

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

on 11.05.24

1 0

Quality Control

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD  
11-05-24

0

Hand Finishing Crosstubes

Ensure no sand is in the tube before alodine.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 67818

Thursday, March 31, 2011 11:48:21 AM



Page 3

Item ID: D407-667-205TRN

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Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 3/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



11-5-24

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack Location: 46



11-5-24

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24

11-0524  
①

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, March 31, 2011 11:48:28 AM

Page 1

Work Order ID: 67818

Parent Item: D407-667-205TRN

Parent Item Name: Crosstube Turning Detail




Start Date: 3/31/2011

Required Date: 4/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
IPP Rev B 08.04.02 Removed polish EC verified by: DD  
IPP Rev:C 08-08-19 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6011-115 		Manufactured	No			120	Each	4.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

LG

4

58413

4

mml 1 and 11/05/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	47818
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b>	D407-667-245
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> F		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	✓		vern	JF-01
	1.832	+0.005/-0.000	1.835	✓		ll	
	1.838	+0.005/-0.000	1.843	✓		ll	
	1.892	+0.005/-0.000	1.897	✓		ll	
	2.052	+0.005/-0.000	2.055	✓		ll	
	2.206	+0.005/-0.000	2.211	✓		ll	
	2.521	+0.005/-0.000	2.526	✓		mirr	CNC-04
	2.633	+0.005/-0.000	2.637	✓		ll	
	4.10	+/-0.030	4.100			vern	JF-01
	4.978	+/-0.030	4.992	✓		vern	JF-01
	2.040	+0.000/-0.010	2.030	✓		vern	JF-01
	0.125	+/-0.010	.130	✓		vern	JF-01
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
SIDE B	2.490	+0.005/-0.000	2.495	✓		vern	JF-01
	1.832	+0.005/-0.000	1.837	✓		ll	
	1.838	+0.005/-0.000	1.843	✓		ll	
	1.892	+0.005/-0.000	1.897	✓		ll	
	2.052	+0.005/-0.000	2.057	✓		ll	
	2.206	+0.005/-0.000	2.211	✓		ll	
	2.521	+0.005/-0.000	2.523	✓		mirr	CNC-04
	2.633	+0.005/-0.000	2.635	✓		mirr	ll
	4.10	+/-0.030	4.100	✓		vern	JF-01
	4.978	+/-0.030	4.987	✓		ll	
	2.040	+0.000/-0.010	2.030	✓		vern	JF-01
	0.125	+/-0.010	.130	✓		vern	JF-01
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
	112.91	+/-0.020	112.930	✓		tape	EC-11

<b>Measured by:</b> M.M.C./mp	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/05/18	<b>Date:</b> 11-05-24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	
E	09.05.20	Dwg Rev updated	KJ	[Signature]

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2673-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67818  
BP11-03-31

RELEASED  
08/11/06

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>RF</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>RF</u>		
CHECKED	<u>RF</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>RF</u>	D407-667-245	SHEET 1 OF 4
APPROVED	<u>RF</u>	TITLE	SCALE
DE APPR.	<u>RF</u>	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

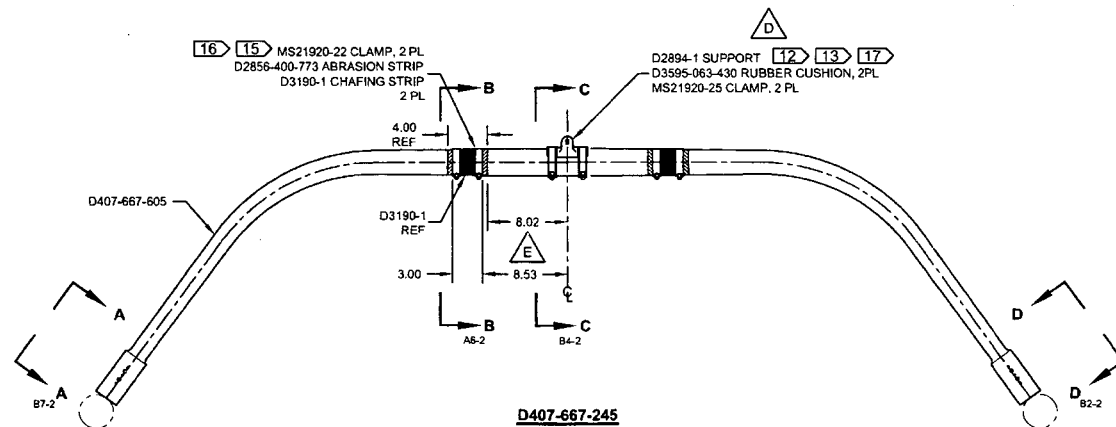
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

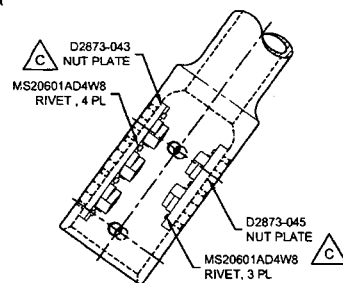
**NOTE:** Date & initial all entries

16 15 MS21920-22 CLAMP, 2 PL  
D2856-400-773 ABRASION STRIP  
D3190-1 CHAFING STRIP  
2 PL

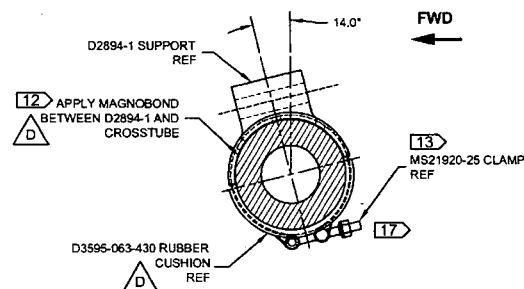
D2894-1 SUPPORT  
D3595-063-430 RUBBER CUSHION, 2PL  
MS21920-25 CLAMP, 2 PL



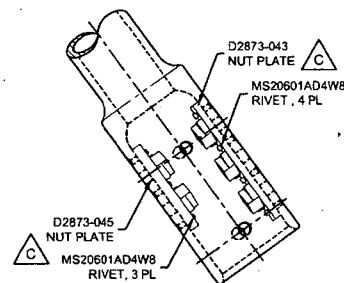
**D407-667-245**  
**ASSEMBLY DETAIL**  
(VIEW LOOKING FWD)



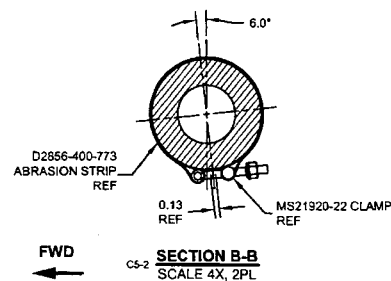
**VIEW A-A CUFF DETAIL**  
SCALE 4X



**SECTION C-C**  
SCALE 4X



**VIEW D-D CUFF DETAIL**  
SCALE 4X



**SECTION B-B**  
SCALE 4X, 2PL

**RELEASED**  
08/11/06

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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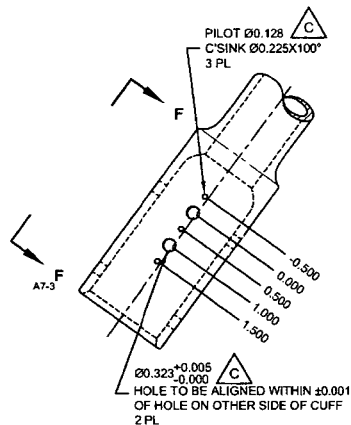
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

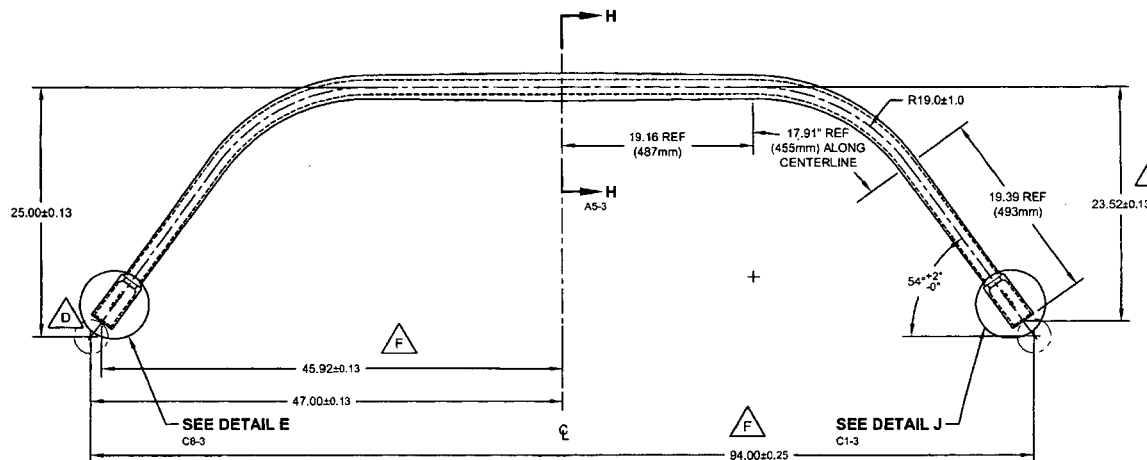
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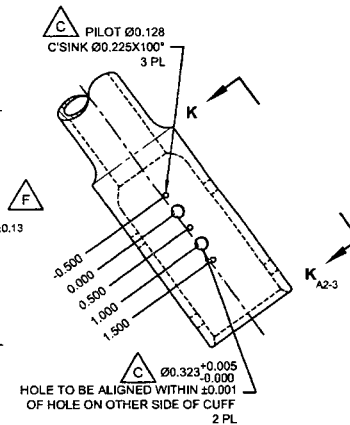
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DETAIL E  
SCALE 4X  
(VIEW LOOKING FWD)

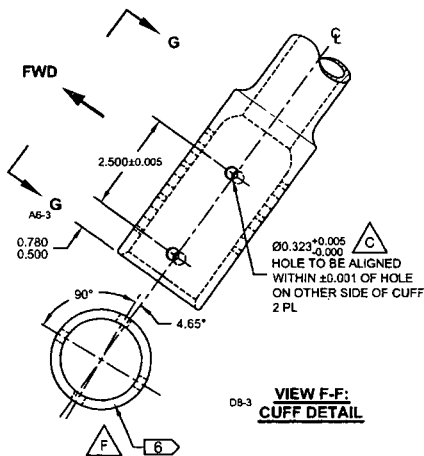


D407-667-605  
BENDING AND DRILLING DETAIL  
(VIEW LOOKING FWD)

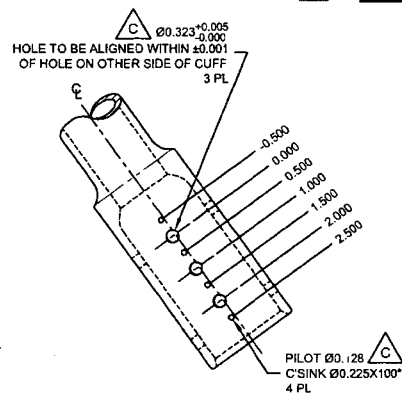


DETAIL J  
SCALE 4X  
(VIEW LOOKING FWD)

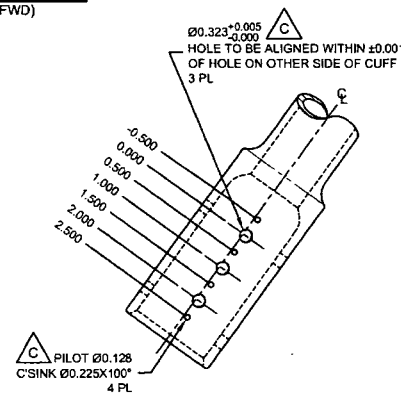
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08/11/06



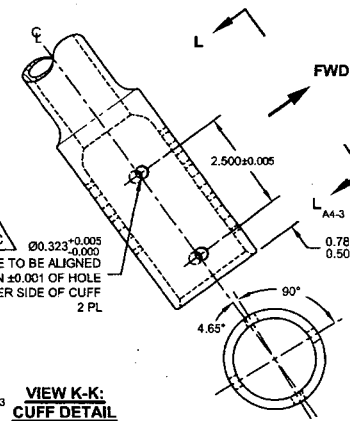
VIEW F-F:  
CUFF DETAIL



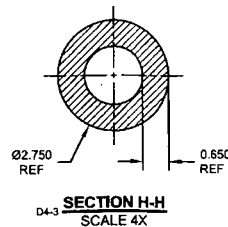
VIEW G-G  
(VIEW LOOKING AFT, ROTATED)



VIEW L-L  
(VIEW LOOKING AFT, ROTATED)



VIEW K-K:  
CUFF DETAIL



SECTION H-H  
SCALE 4X

DESIGN	40	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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W6067815

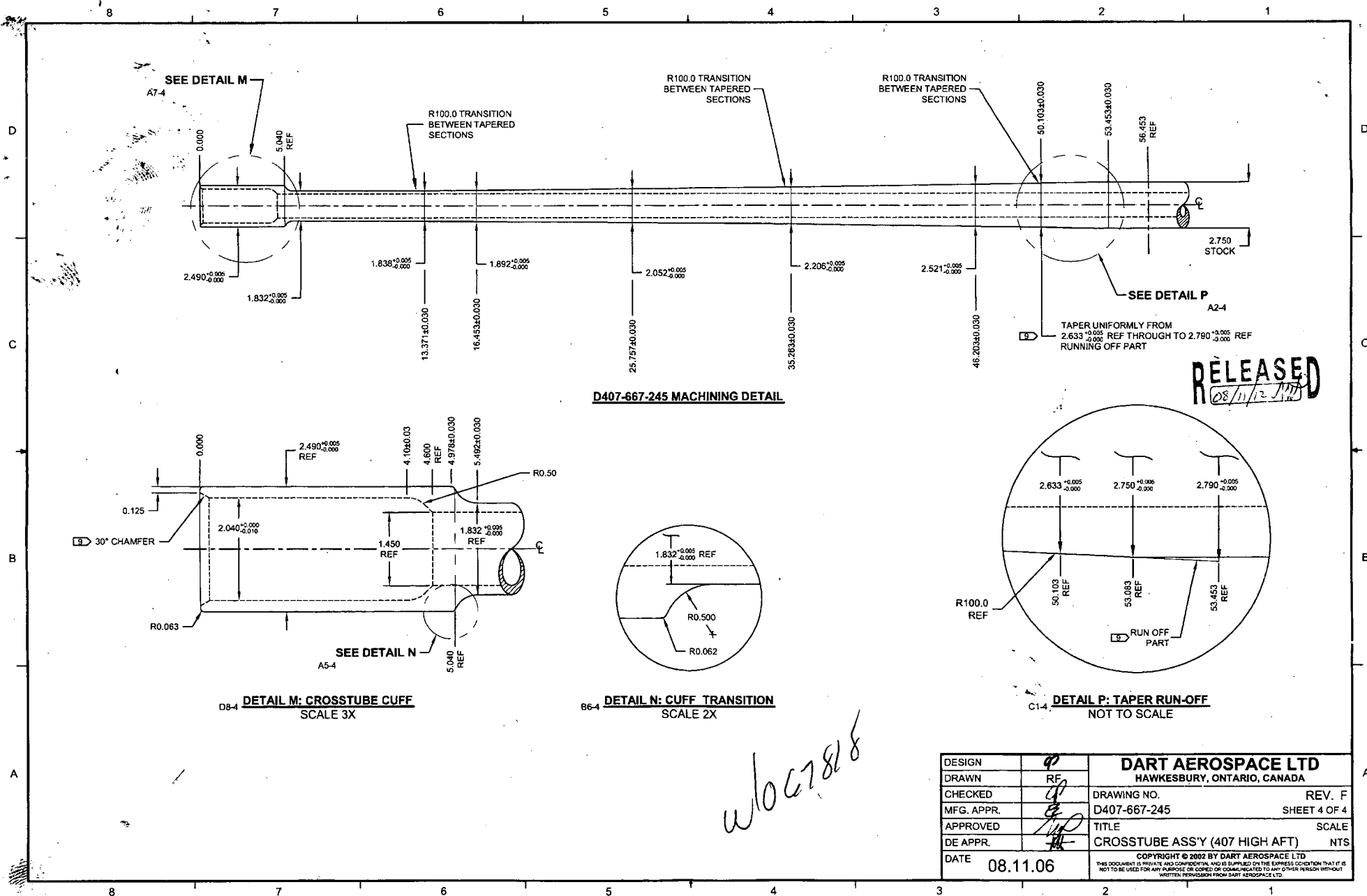
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries